

Work Order ID 60918

Monday, July 26, 2010 3:32:26 PM



Page 1

Item ID: D3836-042

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly (Basket Lid, RH)

Stop



Start Date: 7/26/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 8/3/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

H

Date: 10-07-26

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3836

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3836-2 and D3836-3 rib as per dwg D3836

2- remove identification markings

3- deburr

4- weld D3836-2 to D3836-3 and drill hole (3/16") using DT9447 jig and open to finish size as per dwg D3836

5- weld D2327-3 spacer bushing as per dwg D3836

A/R ER316 S.S. Rod Batch: 109213

6- grind weld flush where indicated on dwg

2

PL 10-07-28

SAM 10-07-28

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

130



QC

Quality Control

Operation
Description

QC9- Inspect visual per QSI004- Fusion Welds

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

(2) AD 10.07.29

0.00

0.00

S. dawt27

(2)

-0012

0.00

0.00

PLC
(WA)

0.00

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

0.00

0.00

PLC 10.07.28

SAD

10-07-29

150



Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

W/O:		WORK ORDER CHANGES						
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Page 3

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Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 7/26/2010 Start Qty: 2.00



Required Date: 8/3/2010 Req'd Qty: 2.00



Reference:

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

10/07/2010

K0-729
2

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Monday, July 26, 2010 3:32:32 PM

Page 1

Work Order ID: 60918



Parent Item: D3836-042



Parent Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 7/26/2010

Required Date: 8/3/2010

Comments: IPP Rev:A 08-12-01 new issue DD verified by:eC

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2327-3 		Manufactured	No			100	Each	31.0000	1	2			

Spacer Bushing

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

WA	31	
58406	1	
58974	1	
59980	9	
60320	20	

PPL 10-07-28

M304TS0.750W.065



Purchased

No

100 f 617.0387 1.7808

3.749053

304 SQ Tube .75x.75x.065W

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

MAT	1.4628	
112398	0	
114482	1.4628	

20 SAD 10-07-28

WA	615.575885	
114520	57.681285	
115274	557.8946	

3.7491

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NOTE: Date & initial all entries

8

7

6

5

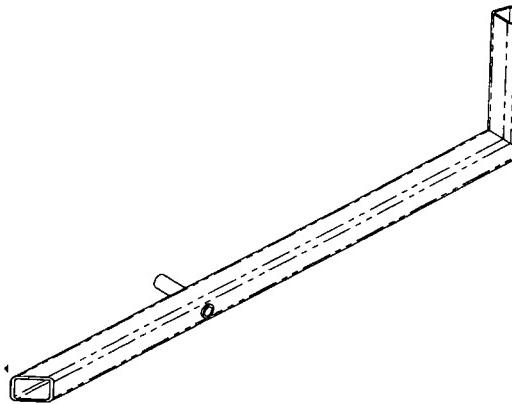
4

3

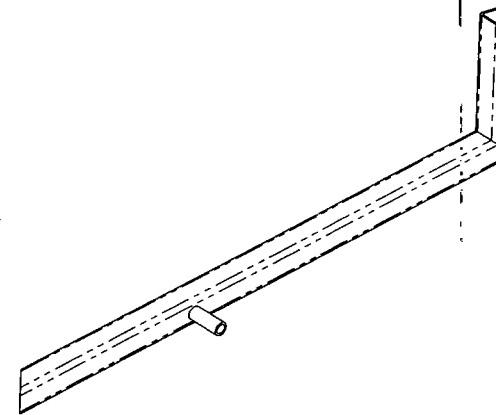
2

D

D



D3836-042 RIB ASSY (BASKET LID, RH)



D3836-041 RIB ASSY (BASKET LID, LH)

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3836-041	RIB ASSY (BASKET LID, LH)
2		X	D3836-042	RIB ASSY (BASKET LID, RH)
3	1	1	D2327-3	SPACER BUSHING
4	1		D3836-1	RIB
5		1	D3836-2	RIB
6	1	1	D3836-3	RIB

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDERS
NO. 60918

09/10-726

RELEASED
09/10/2008

A

A

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.99 lbs EACH
- 8) WELD PER DART QSI 004

C

B

8

7

6

5

4

3

2

1

A	NEW ISSUE		
REV.		MB	08.09.24
DESIGN		BY	DATE
DRAWN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.		REV. A	SHEET 1 OF 3
DATE	08.09.24	SCALE	NTS
RIB ASSY (BASKET LID)			

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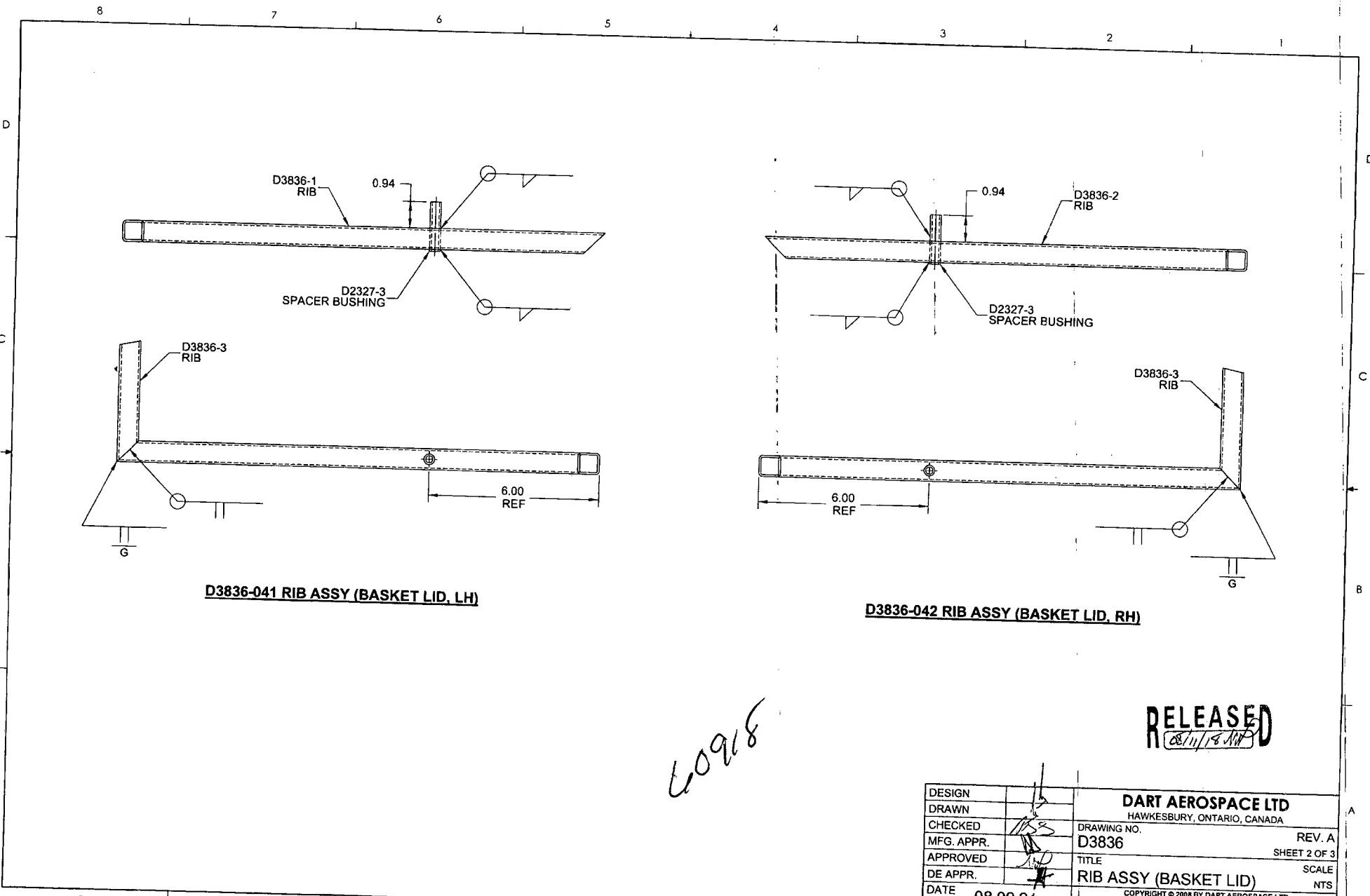
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NOTE: Date & initial all entries



60918
D3836-042 RIB ASSY (BASKET LID, RH)

RELEASED
08/11/18 JMF

DESIGN	<i>[Signature]</i>
DRAWN	<i>[Signature]</i>
CHECKED	<i>[Signature]</i>
MFG. APPR.	<i>[Signature]</i>
APPROVED	<i>[Signature]</i>
DE APPR.	<i>[Signature]</i>
DATE	08.09.24

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. D3836 REV. A
SHEET 2 OF 3
TITLE RIB ASSY (BASKET LID)
SCALE NTS
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NOTE: Date & initial all entries

0.75 X 45°
CHAMFER



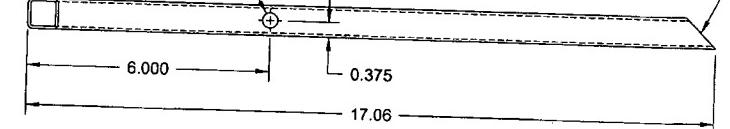
D3836-1 RIB

0.75 X 45°
CHAMFER

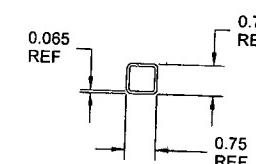
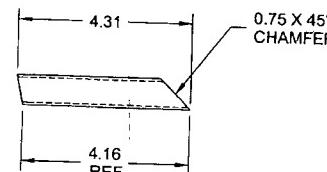


D3836-2 RIB

Ø 0.375^{+0.020}
-0.000 THRU



D3836-3 RIB



TYPICAL SECTION
VIEW

RELEASED
08/11/08

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1 = 0.78 lbs EACH; D3836-3 = 0.19 lbs

U6908

DESIGN	<i>b</i>
DRAWN	<i>b</i>
CHECKED	<i>ASS</i>
MFG. APPR.	<i>MP</i>
APPROVED	<i>MP</i>
DE APPR.	<i>SH</i>
DATE	08.09.24

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3836 REV. A
SHEET 3 OF 3
TITLE RIB ASSY (BASKET LID)
SCALE NTS

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